

Date: Thursday, 04/12/2008 10:33:48 AM
 User: Melanie Fauteux

Process Sheet

| | | | |
|-----------------------|--|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : ANGLE |
| Job Number | : 05064 | | |
| Estimate Number | : 13642 | | |
| P.O. Number | : | Part Number | : D37083 |
| This Issue | : 04/12/2008 S.O. No. : | Drawing Number | : D3708 PRELIM REV.A 09.01.16 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : SMALL /MED FAB | Drawing Revision | : PRELIM prototype |
| Previous Run | : 43915 | Material | : |
| Written By | : | Due Date | : 11/12/2008 Qty: 3 Um: Each |
| Checked & Approved By | : YMF 08-12-04 | | |
| Comment | : Est Rev:A 08-10-31 new issue DD verified by:EC | | |

Additional Product

Job Number:



PRELIMINARY ISSUE
PROTOTYPE

POSITIVE
 RECALL
 FOR ENGINEERING USE ONLY

09.01.16 POC CN# 09502P

| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|------------------|---------------------------|
| 1.0 | M6061T6A750W0625 | angle .750 x .750 x .625w |
|-----|------------------|---------------------------|



P.T.O.



Comment: Qty.: 1.5968 f(s)/Unit Total: 4.7905 f(s)
 angle .750 x .750 x .625w

1107983

FF 08/12/15

(3)

| | | |
|-----|-------------|-------------------------------|
| 2.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: 1- cut to length as per dwg
 2- mark, cut notch and deburr as per dwg
 3- form and bend angle as per dwg D3708

FF 09/01/14
 FF 08/12/15

(3)

(3)

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

09.01.16
ENGINEERING APPROVAL

09.01.15

(3)

| | | |
|-----|-----------------|----------------------------|
| 4.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

09/01/14

| | | |
|-----|-----|---|
| 5.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 09/04/14

(3)

| | | |
|-----|-------------|-----------------------|
| 6.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1






Identify and Stock
 Location: 09

9/6/8

54

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3708-3 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 09/06/08
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: 05064 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------------|------|--|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 09.04.16 | 150 | MATERIAL USED IS H6061T5 INSTEAD OF H6061T6. |  09.04.16 | ACCEPTABLE ON THE BASIS THAT THE D482-761-041 WAS TESTED WITH 6061-T5. |  09/04/16 |  09/04/16 |  09.04.16 |  09/04/16 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 04/12/2008 10:33:48 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 05064

Part Number: D37083

Job Number:



~~PROTOTYPE~~

Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-10

POSITIVE RECALL

EFFECTIVE

09-01-06

AUTH

U

RELEASED

DATE

09.06.05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

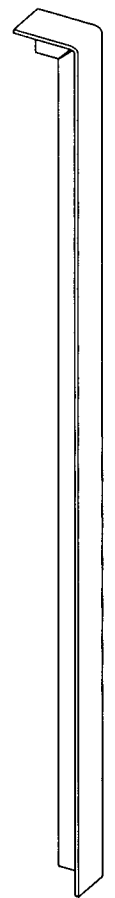
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

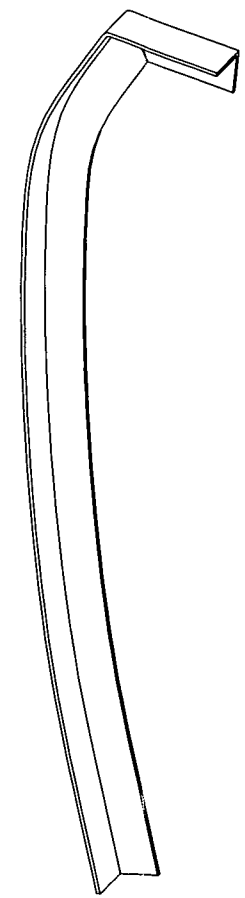
8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D3708-1 ANGLE



8 D3708-3 ANGLE

~~PROTOTYPE~~

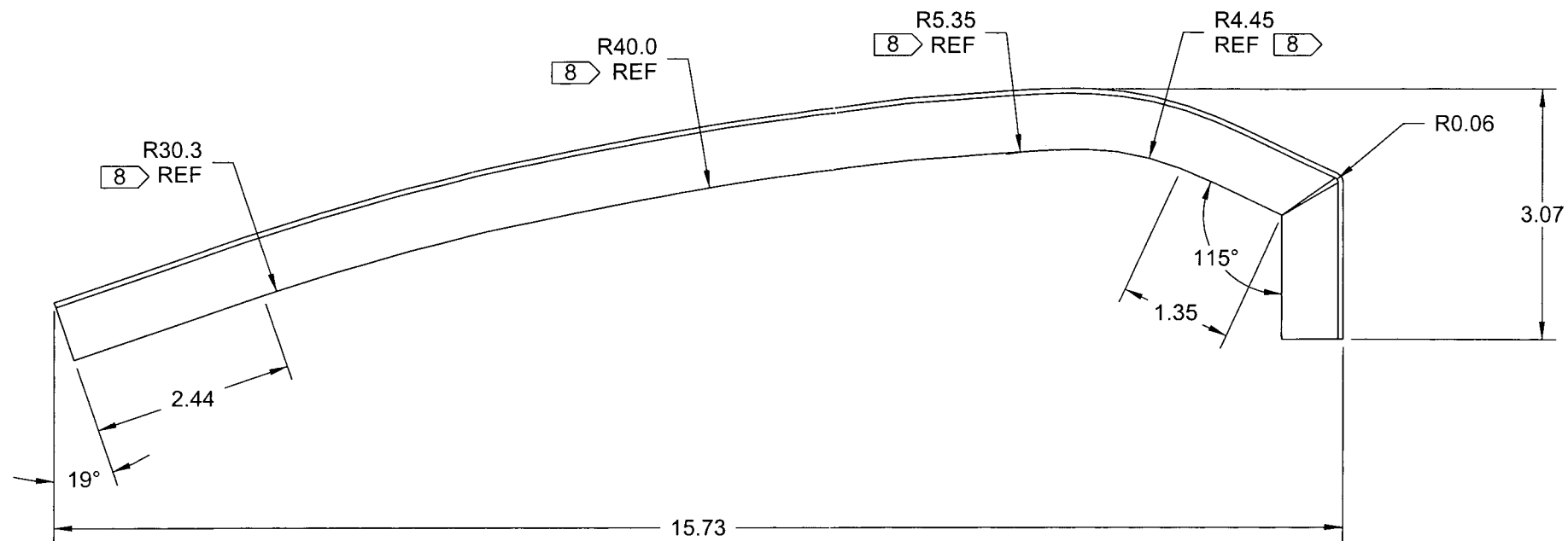
PRELIMINARY
ISSUE
08/16/31 MD

NOTES:

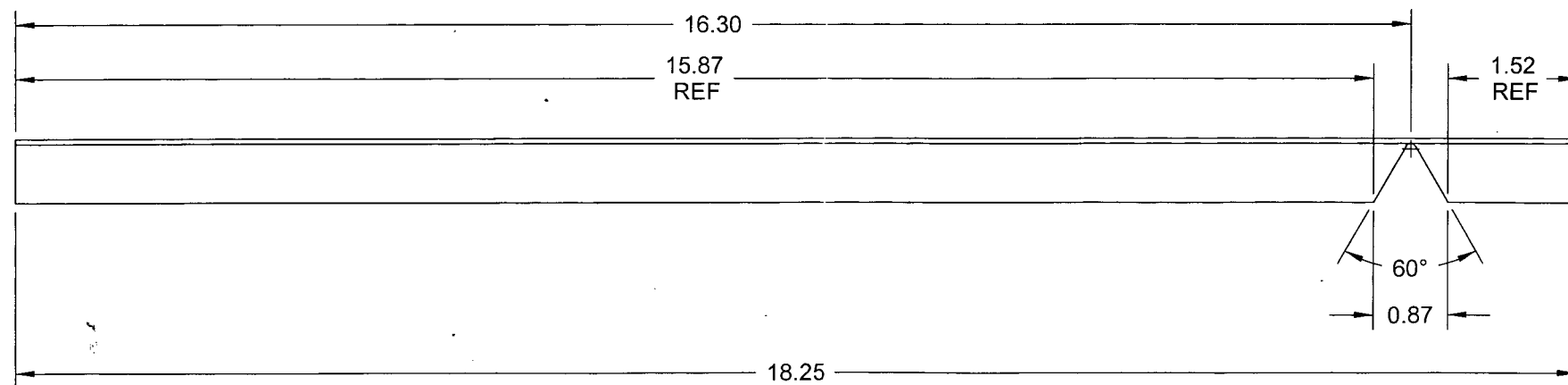
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.063
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3708-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3708-1 = 0.16 lbs
D3708-3 = 0.14 lbs
- 8) CONTROL SHAPE PER DT9019 TEMPLATE

| | | | | |
|------------|-------------|--|--|--------------|
| A | NEW ISSUE | | MB | 08.02.14 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | | | | |
| CHECKED | | DRAWING NO. D3708 | | REV. A |
| MFG. APPR. | | | | SHEET 1 OF 3 |
| APPROVED | | TITLE ANGLE | | SCALE |
| DE APPR. | | | | NTS |
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8 7 6 5 4 3 2 1

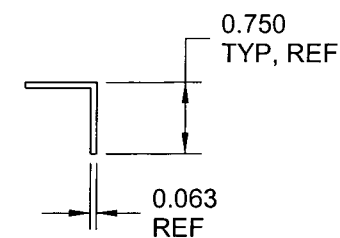


D3708-3 ANGLE
(MAKE FROM D3708-3F)



D3708-3F FLAT PATTERN ANGLE

PRELIMINARY
ISSUE
08/10/31 M



| | | | |
|------------|--|--|--|
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | REV. A SHEET 3 OF 3 |
| DRAWN | | | |
| CHECKED | | DRAWING NO. D3708 | SCALE NTS |
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| DE APPR. | | | |



D3708-1 ANGLE



D3708-3 ANGLE

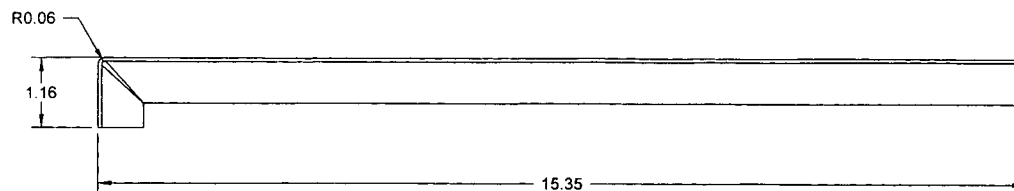
NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.063
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3708-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3708-1 = 0.16 lbs
D3708-3 = 0.14 lbs
- 8) CONTROL SHAPE PER D79019 TEMPLATE

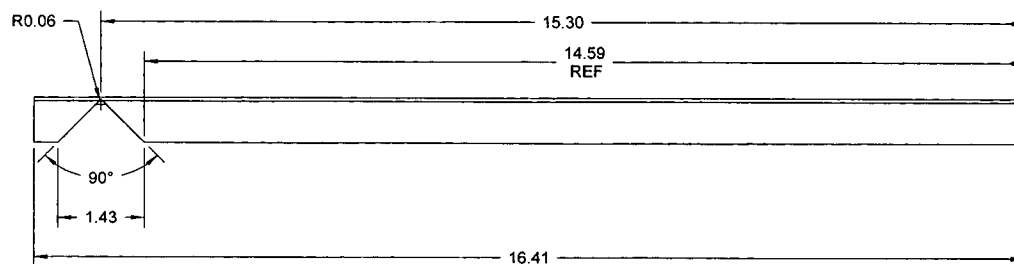
460 05064

RELEASED
9/24/2014

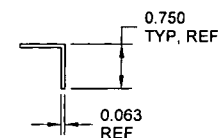
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| A | | NEW ISSUE | | MB | 08.02.14 |
| REV. | | DESCRIPTION | | BY | DATE |
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | |
| DRAWN | | | | | |
| CHECKED | | DRAWING NO. | | REV. A | |
| MFG. APPR. | | D3708 | | SHEET 1 OF 3 | |
| APPROVED | | TITLE | | SCALE | |
| DE APPR. | | ANGLE | | NTS | |
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D3708-1 ANGLE
(MAKE FROM D3708-1F)



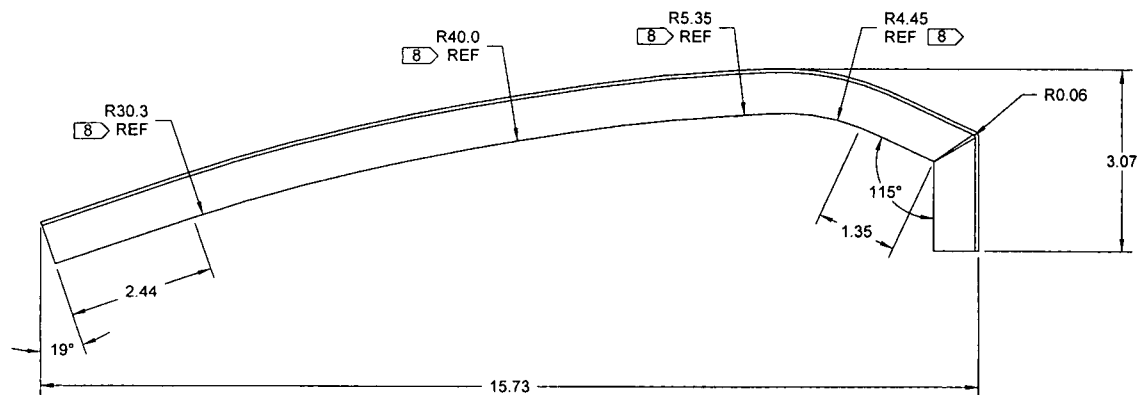
D3708-1F FLAT PATTERN



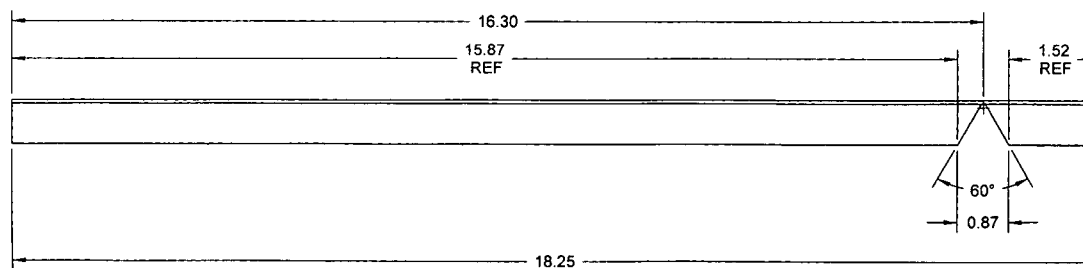
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RELEASED
24/21/2017

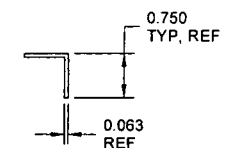
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|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3708 | SHEET 2 OF 3 |
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D3708-3 ANGLE
(MAKE FROM D3708-3F)



D3708-3F FLAT PATTERN ANGLE



RELEASED
09/04/09 MB

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3708 | SHEET 3 OF 3 |
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W605064